



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5162-041
Job Sheet 193471



Part No: D5162-041

Job Qty: 1 pcs

Part Name: Seat Structure Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/15/19

Job Tracking No:

Due Date: 5/6/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3016 REV (DEO) A1, D5162 REV A, D5189 REV A, D3017 REV C IPP REV:A 14.11.05 NEW ISSUE
DD VERF:JLM IPP REV:B 15-02-06 AS PER DWG REV.A DD VERF:JLMIPP REV:C 16.08.31 ADD D3016
PARTS DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Welded Assy-1	1 pcs	5/6/19	5/6/19	24.00	4.63	Large Fab - 1		EL
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
140	QC 5	1 pcs	5/6/19	5/6/19	0.00	0.00	QC 5 - 10		PD 19-05-10
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
165	Large Fab - Welded Assy-2-B4B	1 pcs	5/6/19	5/6/19	0.00	4.63	Large Fab - 1 - B4B		EL
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		



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CANADA
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Container No: S180068



Part: D5162-041

Job No: 193471

Serial No/Batch: S180068

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/10/19

Plex 4/15/19 3:24 PM Dart.lajeunesse.marie

					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
170 QC 9	1 pcs	5/6/19	0.00 0.00	QC 9 - 10		
				QC 9 - 18		
				QC 9 - 24	DAS	
				QC 9 - 43	43	
				QC 9 - 50	9-89	
				QC 9 - 9		
175 QC 5	1 pcs	5/6/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43	DAS	
				QC 5 - 49	43	
				QC 5 - 51	9-89	
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
180 Handfinish - 1-1 Chemical- B4B	1 pcs	5/6/19	0.00 0.47	Handfinish - 1 - 1 - B4B		
				Handfinish - 1 - 2 - B4B		
				Handfinish - 1 - 3 - B4B		
				Handfinish - 1 - 4 - B4B		
				Handfinish - 1 - 5 - B4B		
				Handfinish - 1 - 6 - B4B		
				Handfinish - 1 - 7 - B4B		
				Handfinish - 1 - 8 - B4B		
				Handfinish - 1 - 9 - B4B		
				Handfinish - 1 - 10 - B4B	D.R 19/05/10	
				Handfinish - 1 - 11 - B4B		
				Handfinish - 1 - 12 - B4B		
				Handfinish - 1 - 13 - B4B		
				Handfinish - 1 - 14 - B4B		
				Handfinish - 1 - 15 - B4B		
				Handfinish - 1 - 16 - B4B		
				Handfinish - 1 - 17 - B4B		
				Handfinish - 1 - 18 - B4B		
				Handfinish - 1 - 19 - B4B		
				Handfinish - 1 - 20 - B4B		
					Plex 4/15/19 3:24 PM Dart.lajeunesse.mari	

				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
190 QC 7	1 pcs	5/6/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	DAS 58 MAY 13 2019 9-89
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
200 Small Fab - 2 - B4B	1 pcs	5/6/19	0.00 1.00	Small Fab - 1 - B4B	DAS 58 MAY 13 2019 9-89
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
210 QC 5	1 pcs	5/6/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS 40 MAY 13 2019 9-89
220 Powdercoat - 3 Gray Sand - B4B	1 pcs	5/6/19	0.00 0.29	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
230 QC 3	1 pcs	5/6/19	0.00 0.00	QC 3 - 10	

START: 11:35 O.V. T. 390° FINISH 12:05

BR 19-5-B

					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	68-6 MAY 13 2019 89 DAS
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
240	Small Fab - 3 - B4B	1 pcs	5/6/19	0.00 1.00	Small Fab - 1 - B4B	68-6 MAY 13 2019 89 DAS
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
250	QC 5	1 pcs	5/6/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS MAY 13 2019 68
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
260	Packaging 3-1 - Stock - B4B	1 pcs	5/6/19	0.00 0.00	Packaging 3 - 1 - B4B	DAS
					Packaging 3 - 2 - B4B	46 MAY 14 2019
					Packaging 3 - 3 - B4B	9-89
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	

				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
270 QC 21 - SA	1	5/6/19	0.00 0.00	QC 21 - SA - 21	
	pcs			QC 21 - SA - 70	
				QC 21 - SA - 53	

Dac

21

MAY 14 2019

Part Op 110 - (Weld per dwg A/R 4130 rod Batch: _____), FABRICATE D3017-041 AS PER DWG: USE DT8598 FOR
 Descriptions: BENDING D3017-1/-3 TUBE. USE DT8621 FOR DRILLING (#30 DRILL) BACK FRAME. ***DO NOT OPEN HOLES IT
 WILL BE DONE AT FUTHER STEP*** USE DT8622 FOR DRILLING (#30 DRILL) D3017-5. ***DO NOT OPEN HOLES IT
 WILL BE DONE AT FUTHER STEP*** USE DT8598 JIG FOR WELDING TUBES, LUGS AND ONE END CAP, OTHER
 END CAP WILL BE WELDED AFTER OPENING HOLES.
 140 - (QC5- Inspect part completeness to step on W/O)
 165 - (Weld per dwg A/R 4130 rod Batch: _____), 1- BOLT SEAT FRAME TO ASSEMBLY PLATE DT8624. 2-
 TRANSFER DRILL D5189-041 TO D3016-041 AS PER DWG USING #30 DRILL AND CLECO THEN DRILL TO FINISH
 SIZE. 3- TRANSFER DRILL SEAT PAN TO D5189-041 AND 3016-041. 4- TRASFER DRILL SEAT AND D3016-041 TO
 D3017-041 USING DT _____ AND USING TOOL TO ACHIEVE DESIRED ANGLE ON BACK REST. ARMREST: 1-
 ASSEMBLE AND TRANSFER DRILL D5189-043 TO D3017-041. OPEN HOLES TO FINISH SIZE AS PER DWG SEAT
 BRACE: 1- USE DT10132 AND DT10133 TO TRANSFER DRILL HOLES IN SEAT PAN AND SEAT BRACE.
 170 - (QC9- Inspect visual per QSI004- Fusion Welds)
 175 - (QC5- Inspect part completeness to step on W/O)
 180 - (Chemical Conversion Coat per QSI005 4.1), CHEMICAL CONVERSION SEAT PANEL D3022-1 AND BACK
 PANEL D3023-1 AS PER DWG
 190 - (QC7-Inspect Chemical Conversion Coat)
 200 - (TO FABRICATE D5162-051) ASSEMBLE D3023-1 PANEL TO D3017-041 BACK FRAME AS PER DWG D5162-
 051
 210 - (QC5- Inspect part completeness to step on W/O)
 220 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3), POWDER COAT ALL INDIVIDUAL PARTS START TIME:
 _____ OVEN TEMPERATURE: _____ FINISH TIME: _____
 230 - (QC3- Inspect Part Finish)
 240 - ASSEMBLE AS PER DWG
 250 - (QC5- Inspect part completeness to step on W/O)
 260 - (Identify as per dwg & Stock Location: _____)
 270 - (QC21- Final Inspection - Work Order Release)

Job BOM

509606

Part / Item	Component Name	Quantity	Operation	Container
D2199-31	Strut Details	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	51522779
D3016-1	Tube	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5149782
D3016-11	Saddle	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5037785
D3016-3	Tube	4 pcs (4 ea)	110-Large Fab - Welded Assy-1	5149863
D3016-5	Tube	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5158854
D3016-7	Tube	4 pcs (4 ea)	110-Large Fab - Welded Assy-1	5159593
D3016-9	Saddle	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5159270
D5159-041	Seat Back Brace Assembly	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5177511
D5159-043	Seat Back Brace Assembly	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5153366
D5159-045	Seat Rib Assembly	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5152041
M4130NT0.750W.049	4130 Round Tube .750 X.049W	13.8000 ft (13.8 ea)	110-Large Fab - Welded Assy-1	5155281
M4130NT0.750W.083	4130 Round Tube .750 X.083W	2.5000 ft (2.5 ea)	110-Large Fab - Welded Assy-1	5060104
D3016-13	Bracket	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5109116
D3016-15	Gusset	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	7103100
D3016-17	Gusset	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5103200
D3017-11	Cap	4 pcs (4 ea)	110-Large Fab - Welded Assy-1	5103203
D3017-7	Lug	3 pcs (3 ea)	110-Large Fab - Welded Assy-1	5019245
D3020-1	Fitting	4 pcs (4 ea)	110-Large Fab - Welded Assy-1	5152198
D3022-1	Seat Pan	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5064778
D3023-1	Back Panel	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5177829
D4667-041	Armrest Stud Assembly	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5162717
D5190-1	Armrest Fitting	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5025169
D5190-3	Weld Pin	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5146053
GA016 MS20600-AD4W2	Rivet	40 Ea (40 ea)	200-Small Fab - 2 - B4B	5110002
WA003 MS20600-AD4W3	Cherry Rivet	6 Ea (6 ea)	200-Small Fab - 2 - B4B	5135768
ST349 AN3-12A	Bolt	3 Ea (3 ea)	240-Small Fab - 3 - B4B	5133167
ST344 AN4-14A	Bolt	2 Ea (2 ea)	240-Small Fab - 3 - B4B	5157440
ST346 AN4-4A	Bolt	1 Ea (1 ea)	240-Small Fab - 3 - B4B	5148460
ST345 AN4-6A	Bolt	1 Ea (1 ea)	240-Small Fab - 3 - B4B	5163234
ST301 AN970-4	Washer	1 Ea (1 ea)	240-Small Fab - 3 - B4B	5166689
ST015 D3024-1	Spacer	3 pcs (3 ea)	240-Small Fab - 3 - B4B	5155322
GA126 D3031-1	Loop	2 pcs (2 ea)	240-Small Fab - 3 - B4B	5089714
WA003 MS20600-AD4W4	Rivet	4 Ea (4 ea)	240-Small Fab - 3 - B4B	5141237-1
ST303 MS20600-AD4W5	Blind Rivet	8 Ea (8 ea)	240-Small Fab - 3 - B4B	fm131618
ST303 MS21042L3	Nut	17 Ea (17 ea)	240-Small Fab - 3 - B4B	5131462
ST286 MS21042L4	Nut	8 Ea (8 ea)	240-Small Fab - 3 - B4B	5158232
ST280 MS24693-S272	Screw	4 Ea (4 ea)	240-Small Fab - 3 - B4B	5074201
ST280 MS27039-1-17	Screw (601.1954)	1 Ea (1 ea)	240-Small Fab - 3 - B4B	fm127831
ST280 MS27039-1-18	Screw	3 Ea (3 ea)	240-Small Fab - 3 - B4B	fm124526
ST280 MS27039-1-19	Screw	4 Ea (4 ea)	240-Small Fab - 3 - B4B	5136890
ST279 MS27039-1-20	Screw	2 Ea (2 ea)	240-Small Fab - 3 - B4B	5044554
ST279 MS27039-4-20	Screw	4 Ea (4 ea)	240-Small Fab - 3 - B4B	5039085
ST264 MS27039-4-21	Screw	2 Ea (2 ea)	240-Small Fab - 3 - B4B	fm135714
ST264 NAS1149D0332J	Washer	30-Ea (30 ea)	240-Small Fab - 3 - B4B	5167209
ST264 NAS1149D0432J	Washer	17 Ea (17 ea)	240-Small Fab - 3 - B4B	5093756
ST264 NAS43DD4-16FC	Spacer	2 Ea (2 ea)	240-Small Fab - 3 - B4B	5007039

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	D2199-31	1	8	0
	D3016-1	2	14	0
	D3016-11	2	6	0
	D3016-13	2	12	0
	D3016-15	2	22	0
	D3016-17	2	34	0
	D3016-3	4	4	0
	D3016-5	2	6	0
	D3016-7	4	8	0
	D3016-9	2	6	0
	D3017-11	4	21	0
	D3017-7	3	12	0
	D3020-1	4	12	0
	D3022-1	1	1	0
	D3023-1	1	0	0
	D4667-041	1	19	0
	D5159-041	1	0	0
	D5159-043	1	1	0
	D5159-045	1	3	0
	D5190-1	1	3	0
	D5190-3	1	9	0
	M4130NT0.750W.049	14	106	0
	M4130NT0.750W.083	3	29	0
200-Small Fab - 2 - B4B	MS20600-AD4W2	40	165	0
	MS20600-AD4W3	6	536	0
240-Small Fab - 3 - B4B	AN3-12A	3	260	0
	AN4-14A	2	668	0
	AN4-4A	1	35	0
	AN4-6A	1	977	0
	AN970-4	1	137	0
	D3024-1	3	37	0
	D3031-1	2	8	0
	MS20600-AD4W4	4	3,082	0
	MS20600-AD4W5	8	91	0
	MS21042L3	17	3,514	0
	MS21042L4	8	3,950	0
	MS24693-S272	4	633	0
	MS27039-1-17	1	40	0
	MS27039-1-18	3	1,137	0
	MS27039-1-19	4	709	0
	MS27039-1-20	2	64	0
	MS27039-4-20	4	46	0
	MS27039-4-21	2	57	0
	NAS1149D0332J	30	3,478	0
	NAS1149D0432J	17	274	0
	NAS43DD4-16FC	2	55	0

Part Specifications

Specifications could not be found.

Plex 4/15/19 3:24 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					